

Date: Monday, 15/12/2008 12:44:25 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI-ACCESS STEP RH (FOLDING)		
Job Number	: 44084		Part Number	: D412630034		
Estimate Number	: 12568		Drawing Number	: IIN D412-630		
P.O. Number	:		Project Number	: N/A		
This Issue	: 15/12/2008	S.O. No. :	Drawing Revision	: L		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type :	Due Date	: 15/12/2008 Qty: 1 Um: Each		
Previous Run	: 41647					
Written By	:					
Checked & Approved By	:					
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by:DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		<i>for JUD 08.12.16</i>	
		<i>5081216</i>	
		Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG003	
2.0	D2012107	Clevis	
		<i>1/12/15</i>	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Clevis Pick:	
	Qty Part Number	Description	Batch
	1 D2012-107	Clevis	<i>B27522</i>
3.0	D2803042	Bracket Assembly	
		<i>8/12/15</i>	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Pick:	
	Qty Part Number	Description	Batch
	1 D2803-042	Bracket Assembly RH	<i>B34017</i>
4.0	D2804042	Bracket Assembly	
		<i>8/12/15</i>	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Pick:	
	Qty Part Number	Description	Batch
	1 D2804-042	Bracket Assembly RH	<i>B355827</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 15/12/2008 12:44:25 PM
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Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2807041	Door prop
-----	----------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Prop

Batch: B3351

8/12/15

sd

6.0	D2813	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	B334020

8/12/15

sd

7.0	D3562042	Step Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-042	Step Weldment RH	B411649

8/12/15

sd

8.0	D33951	Bushing
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	B41035

8/12/15

sd

9.0	AN3C21A	BOLT
-----	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	K101169

8/12/15

sd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M102736

8/12/15 SP

11.0 AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M106431

8/12/15 SP

12.0 MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M106763

8/12/15 SP

13.0 NAS151H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS151H3	Washer

Batch

M107101

8/12/15 SP

14.0 NAS151H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS151H5L	Washer

Batch

M104956

8/12/15 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0 NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H8	Washer	<u>M109099</u>

16.0 MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
4	MS21043-3	Nut	<u>M109535</u>

17.0 MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	<u>M101390</u>

18.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: 1109929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: 1104251

110812/16/08

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

110812/16/08 (X)

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Job Number: 44084

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number Description Batch

2 D2806-1 Bushing

35630

SS 08/10/16 (X)

22.0 D28063 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number Description Batch

2 D2806-3 Bushing

36534

SS 08/10/16 (X)

23.0 D28105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number Description Batch

1 D2810-5 Strut

40900

SS 08/10/16 (X)

24.0 D33961 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number Description Batch

2 D3396-1 Spacer

41670

SS 08/10/16 (X)

25.0 AN4C6A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4C6A Bolt

M109147

SS 08/10/16 (X)

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Job Number: 44084

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	AN4C6A	Bolt
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26.0	AN4C10A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M104679

27.0	AN4C15A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M107082

28.0	AN44C7A	Eyebolt
------	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	M109013

29.0	AN5C15A	Bolt
------	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M105125

30.0	NAS1515H4	Washer
------	-----------	--------



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M108880

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 44084

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	

M108334



88/08/10/16 (X)

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	

M109166.

88/08/10/16 (X)

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	

M109535

88/08/10/16 (X)

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



88/08/10/16 (X)

Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location: 11

PPP Rev: Rev A

88/08/10/16 (X)

36.0 QC21 FINAL INSPECTION/W/O RELEASE



08/12/16 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



88/08/10/16 (X)

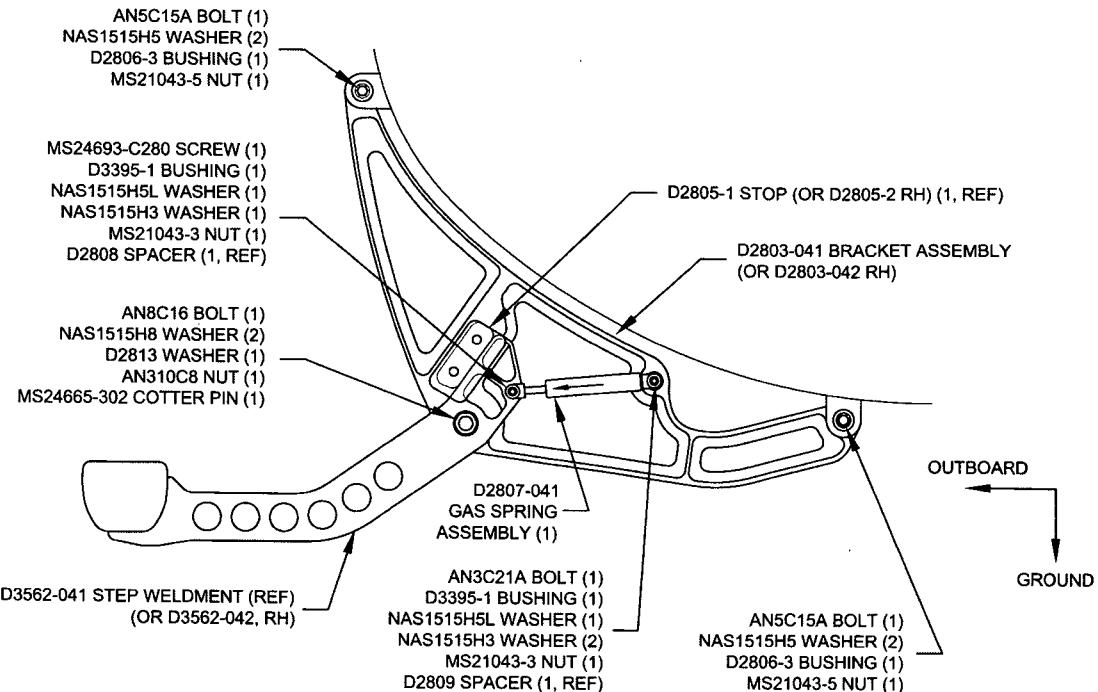
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

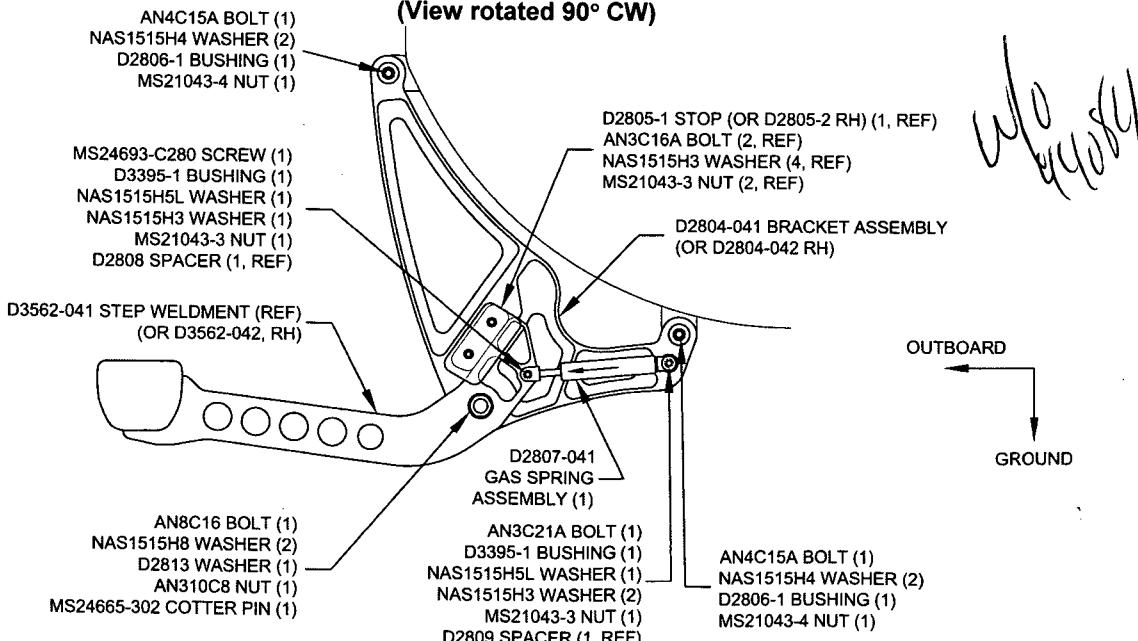


FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

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25-00-00

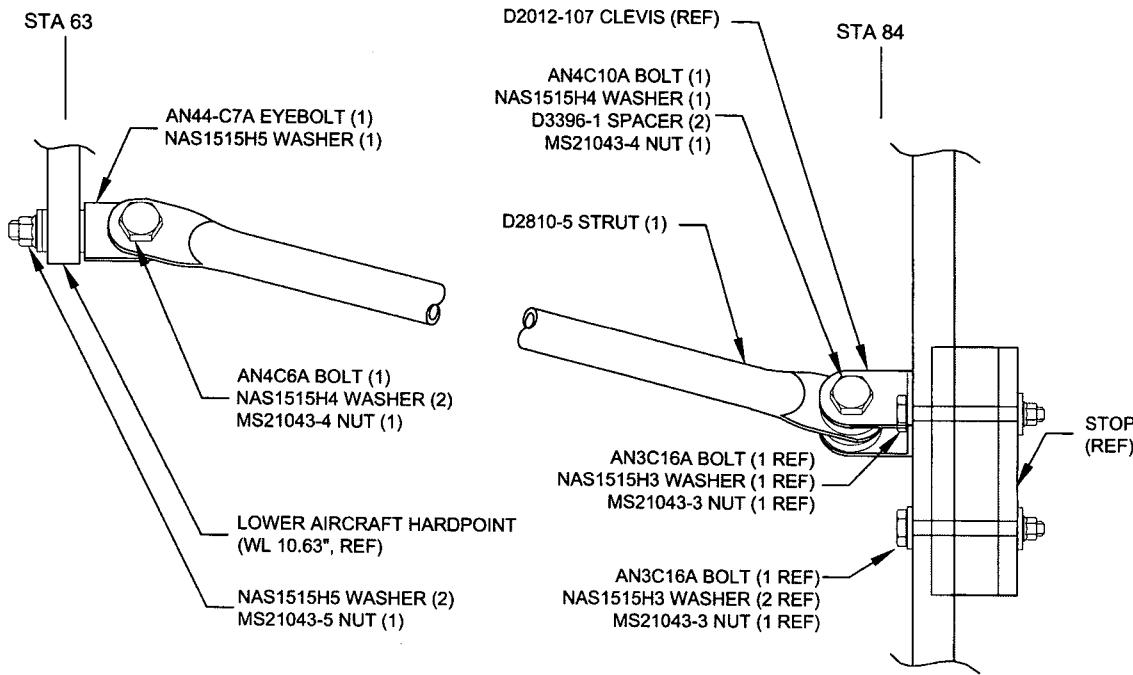


FIGURE 25-15: Strut Detail for D412-630-033/-034 *Heli-Access-Step™* Installation
(NOT TO SCALE)

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